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C45-15-10
Job Sheet 170945



Part No: C45-15-10

Job Qty: 4 ea

Part Name: Ford Bumper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 7/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-15-10 REV.3 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/9/18	0.00	0.00	Start Up Small Fab-1		Smf
100	Small Fab	4 pcs		7/9/18	0.00	2.00	Small Fab-3		SDAS
120	QC	4 pcs		7/9/18	0.00	0.00	QC5		38
140	Packaging	4 pcs		7/9/18	0.00	0.00	Packaging3-1		8218-7-3
160	QC21-SA	4 Ea		7/9/18	0.00	0.00	QC21		21

Part Op 100 - Modify as per dwg.
Descriptions:

21
3-89 JUL 04 201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
E3TZ-4730-A	Bumper	4 Ea (1 ea)	90-Start up Operation	5070539

Job Allocations

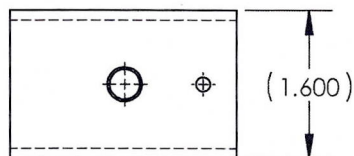
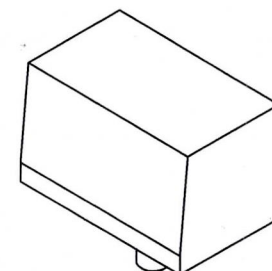
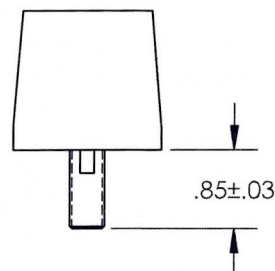
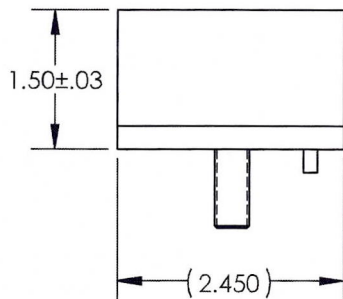
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	E3TZ-4730-A	4	26	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/6/2012	JAG	
3	15-0102	CH'D DIMESION WAS (2.000) IS 1.50±.03 TO ACCOMODATE NEW CAGE DESIGN.	5/7/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170945 HWS
180626

DART AEROSPACE	
TITLE FORD BUMPER	
DWG NO. C45-15-10	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weid</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 9/12/1997 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-15-10	1	FORD BUMPER		(#E3TZ-4730-A) MODIFIED



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		AGAINST DEPARTMENT/PROCESS		DISPOSITION	
Part No. _____	Water Jet _____	Cross tube _____	Skid-tube _____	Rework _____	Suspected Unapproved _____
NCR No. _____	Prod. Eng. Coord. _____	Small Fab _____	Machining _____	Scrap _____	Use-as-is _____
Date: _____	Rec/Store/Packaging _____	Finishing _____	Thermoforming _____	Use-as-is _____	Use-as-is _____
Ste _____	Supplier _____	Composite _____	Large Fab _____	Use-as-is _____	Use-as-is _____
Description Work C _____		Machining _____			

DART AEROSPACE

Container No: S084778

Part: C45-15-10

Job No: 170945

Serial No/Batch: S084778

Revision: 3

Inspector: _____

Exp Date: _____

Instructions: _____

Date: 06/27/18

Root Cause	
Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

OTHER :	
Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified
Cuffs	Contamination
Crushing	Countersink
Heat Treat	Cut Too Short
Wave/Twist in Tube	Instructions Incomplete/Unclear
Marks/Chatter	Drill Holes
Wrong Stock Pulled	Out of Sequence
Off-set	Misaligned/off center
Mislabeled	Fit/Function
Positioned Wrong	Turning Sequence
Outside Dimensions	
Over/Under tolerance	
Part Incorrect	
Part Lost/Missing	
Part Moved	
Drawing	
Finish	
Misread	

Completed By	
Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval	

MRB (QS042) Approval	
Engineering	
Quality	
Other	